

Date: Tuesday, 11/14/2006 10:03:43 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|-----------------|
| Customer | CU-DAR001 Dart Helicopters Services | Drawing Name | BAFFLE ASSEMBLY |
| Job Number | 29423 | Part Number | D3276042 |
| Estimate Number | 11265 | Drawing Number | D3276 REV B |
| P.O. Number | N/A | Project Number | N/A |
| This Issue | 11/14/2006 | S.O. No. | N/A |
| Prsht Rev. | NC | Drawing Revision | B |
| First Issue | N/A | Material | N/A |
| Previous Run | 28410 | Due Date | 11/17/2006 |
| Written By | <i>[Signature]</i> | Qty: | 20 |
| Checked & Approved By | <i>[Signature]</i> | Um: | Each |
| Comment | Est Rev:A New Issue 05-12-06 JLM Est Rev:B Now on Waterjet 06-09-06 JLM | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|------|
| 1.0 | M6061T6S040 | 6061-T6 .040 Sheet | |
| | | Comment: Qty.: 1.0715 sf(s)/Unit Total: 21.4305 sf(s) Material: 6061-T6 (QQ-A-250/11) 0.040" thick (M6061T6S.040) Batch: <i>m100742</i> <i>M/06/12/04</i> | (20) |
| 2.0 | WATER JET | FLOW WATER JET | |
| | | Comment: FLOW WATER JET 1-Cut as per Dwg D3276 Dwg Rev: <i>B</i> <i>M/06/12/05</i> Prog Rev: <i>B</i> | (20) |
| | | 2-Deburr if necessary | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | <i>M/06/12/05</i> | (20) |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | |
| 4.0 | QC8 | SECOND CHECK | |
| | | <i>M/06/12/06</i> | (20) |
| | | Comment: SECOND CHECK | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 | |
| | | 1-Deburr | |
| | | SAY 06:12:09 | (20) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Re: Tuesday, 11/14/2006 10:03:43 AM
Ser: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 29423

Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Roll as per Dwg D3276

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276 ,check with template DT8825

SB 07/01/05

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.A./a.m

07/01/08

20x

9.0

POWDER COATING

POWDER COATING



M102391

20x

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.G./y

07/01/08

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml

07/01/08

11.0 D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total : 45.0000 f(s)

Pick:

Qty Part Number Description Batch

27.0" D2464 Neoprene Seal B28812

ml

12.0 D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3276-3 Decal B28810 (X16)

B29440 (X4)

ml

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/12
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:03:43 AM
User: Kim Johnston

Process Sheet

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Drawing Name: BAFFLE ASSEMBLY

Job Number: 29423

Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3276

ml 07/01/09

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Mo 07/01/09 (20)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5105

JB 07/01/09 (20) 07/01/09

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/10 (20)

Job Completion



U 07.01.12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

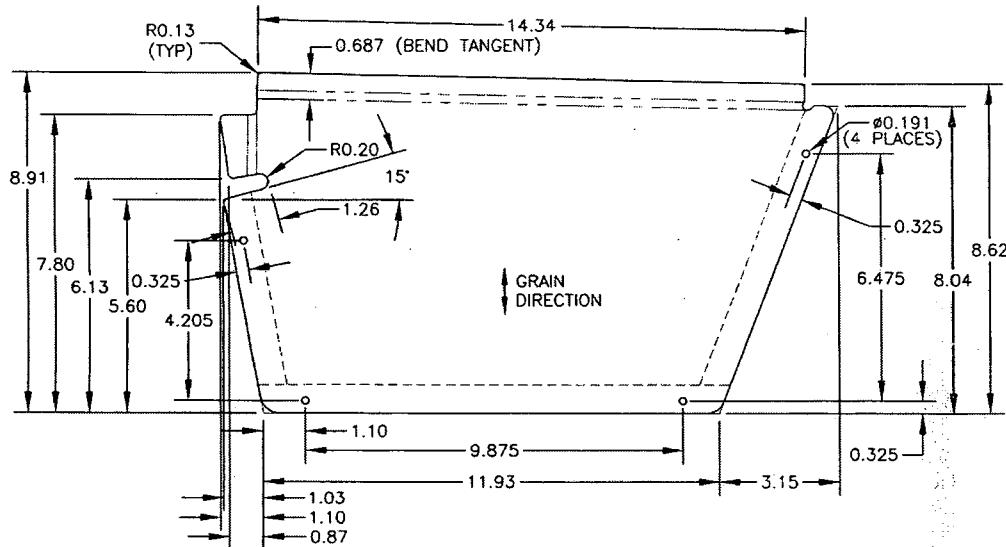
| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 29423 |
| Description: Baffle | Part Number: | D3276-1 |
| Inspection Dwg: D3276 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

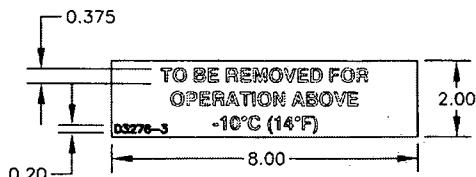
| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | MLM | Audited by: | DS | Prototype Approval: | N/A |
| Date: | 06/12/05 | Date: | 06/12/05 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------------|--|
| A | 05.04.26 | New Issue | P/O D044-717-011 | KJ/JLM <i>[Signature]</i> <i>[Signature]</i> |



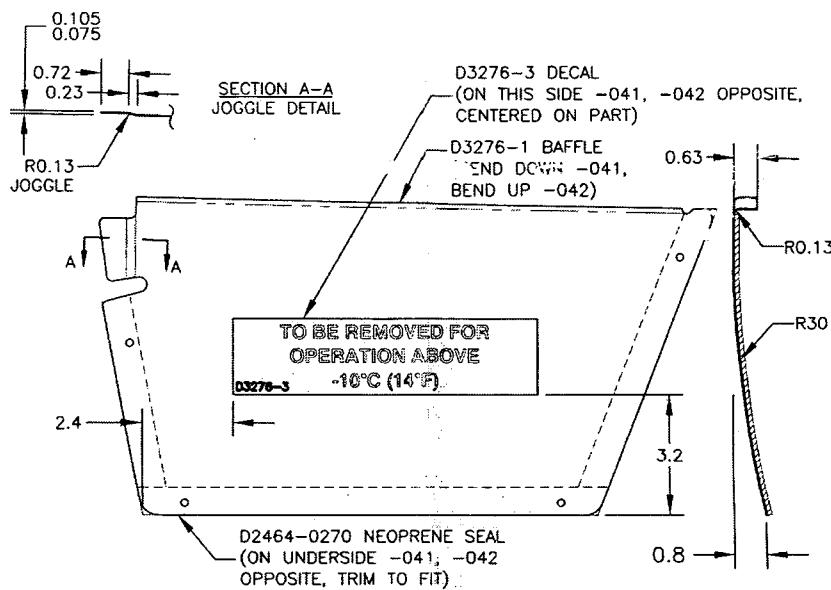
D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)
D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29423

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CART AEROSPACE LTD.

| | | | | |
|----------|-----------------|-----------------------------|---|------------|
| B | 05.01.25 | LABEL NOW -10°C; CURVE PART | | |
| A | 05.01.07 | NEW ISSUE | | |
| DESIGN | DRAWN BY | DART | DART AEROSPACE LTD. HORNSEY, ONTARIO, CANADA | |
| CP | CP | | | |
| CHECKED | APPROVED | DRAWING NO. | REV. | SHEET 1 OF |
| | | D3276 | | |
| DATE | TITLE | | | SCALE |
| 05.01.25 | BAFFLE ASSEMBLY | | | 1: |